

AMENDMENT TO THE ABSTRACT:

Page 14

Please amend the Abstract on page 14 as follows:

ABSTRACT

A method for determining a deviation of at least one regulating variable on chip removal machines with a mechanical drive for a tool and/or a workpiece, regulated by a control system, wherein the regulation comprises a plurality of values of at least three spatial axes for the control system and for the drive, and the values have a functional relation with the axes. A protocol is prepared from a plurality of control system actual values detected by measuring **[[means]]** devices and/or selected drive actual values and a control system nominal value and/or a drive nominal value is calculated at least in relation to an axis, and a control system differential value and/or a drive differential value is calculated at least in relation to the axis. A chip removal machine which implements such a method is also disclosed.